

Work Order ID 57948

April 21, 2010 8:41:55 AM



Page 1

Item ID: D2739

Accept



Setup Start



Revision ID:

Item Name: 350 I Beam

Stop



Start Date: 21/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2739

Rev D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739. □2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 □3-Use uni-bit to open holes to finish size as per Dwg D2739. □4-Bevel Fwd end of extrusion and Deburr holes and ends. □5-Deburr

6 - - AWM
10-04-23
Plu =>

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

x6 0 2E 10/04/26

120

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 - - AWM
10-4-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2739 PAR #: N/A Fault Category: Skid tubes NCR: Yes No DQA: JA Date: 10.04.27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: JA Date: 10/04/27

NCR: <u>57948</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/26	<u>100</u>	Qty of web cut to short by 1" R.C. Lack of attention when cut to length.	<u>JA</u> <u>Q2702</u>	- Scrap web. + Reckle Qty of B+ <u>57814</u>	<u>AWM</u> <u>10-4-26</u>	<u>S</u> <u>10/04/26</u>	<u>JA</u> <u>Q2702</u>	<u>S</u> <u>10/04/26</u>
				- inform employee to measure twice and cut once to prevent mistakes. PAY ATTENTION!	<u>JA</u> <u>10-4-26</u>	<u>S</u> <u>10/04/26</u>		<u>S</u> <u>10/04/26</u>

NOTE: Date & initial all entries

Work Order ID 57948

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Item ID: D2739

Accept



Setup Start



Revision ID:

Item Name: 350 I Beam

Stop



Start Date: 21/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-4-26

(6)

140

Identify as per dwg & Stock Location:

L-G

0.00



Packaging

Memo

0.00

Packaging

6 - - HUM
10-4-23

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/26

mf
10-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:41:58 AM

Page 1

Work Order ID: 57948



Parent Item: D2739

Parent Item Name: 350 I Beam

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev: C 02.11.28 Reformat KJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2600-5-108		Manufactured	No			100	Each	222.0000	6.0000			



Extrusion 'I Beam' thin



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

222

38589

4

47814

218

AWM 10-4-23 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

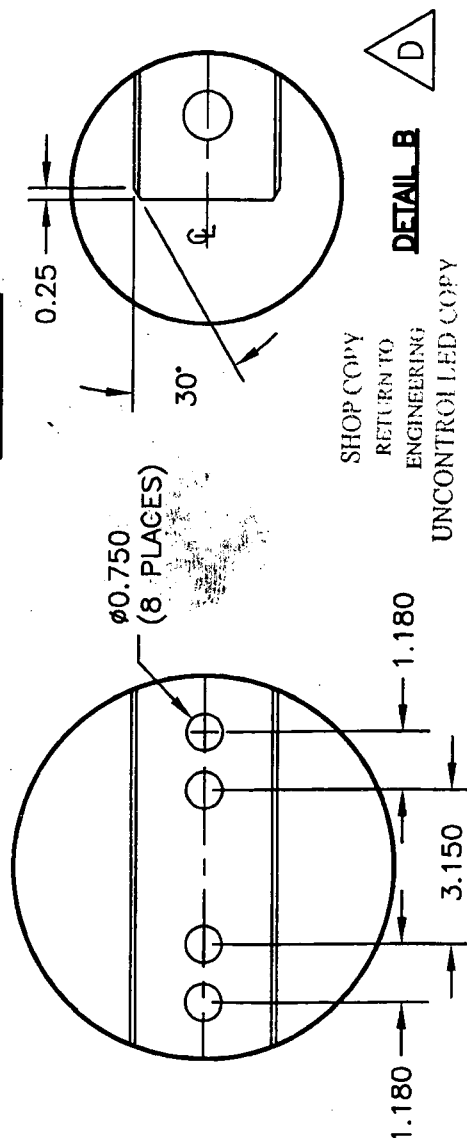
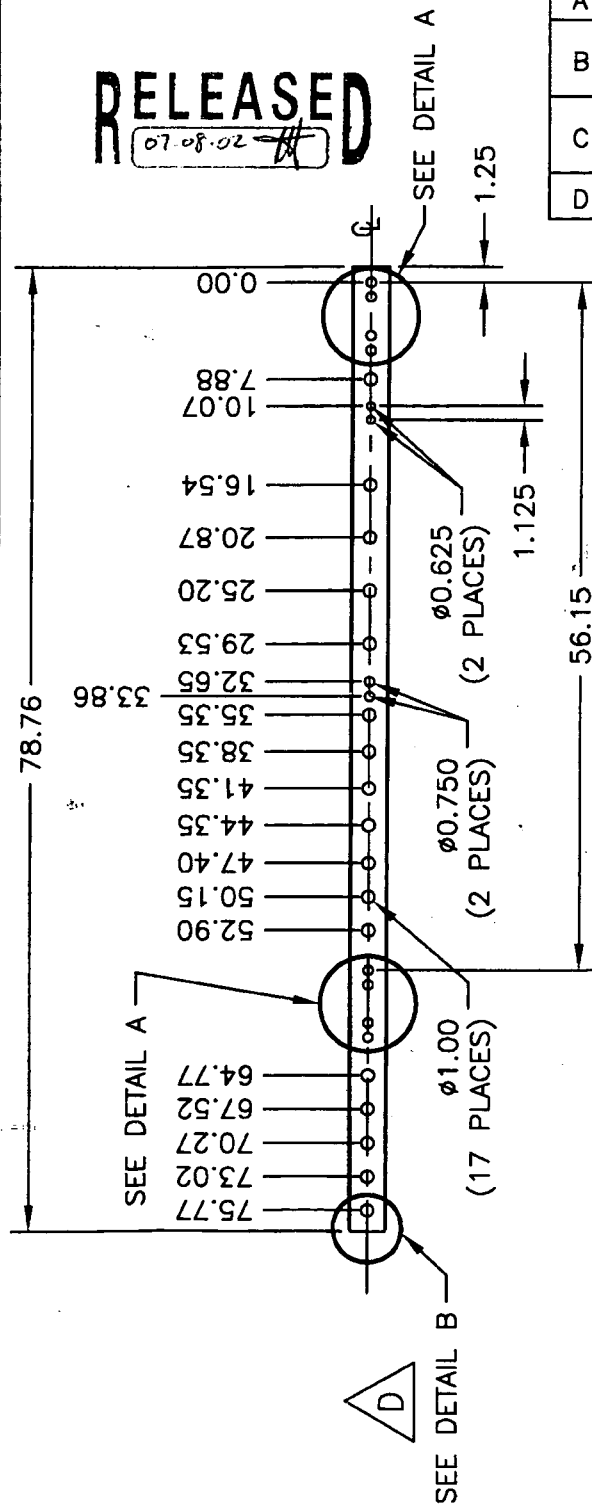
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07-08-02

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D2739	REV. D SHEET 1 OF 1
DATE 07.05.29	TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B	

**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT ϕ

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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